

5/25

DART AEROSPACE LTD	Work Order:	<i>23201</i>
Description: 3" Skid extrusion (no outer ridge)	Part Number:	D2600-3-120
Drawing: D2600 Rev. D1	Qty:	<i>120 159</i>

Step	Location	Procedure	By	Date	qty
1	DC	Issue Traveller	<i>AF</i>	<i>05/05/09</i>	<i>120</i>
2	PG	Issue P/O: <i>7008021</i> a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897122 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	<i>U</i>	<i>05/05/10</i>	<i>140</i>
3	RG	Inspect for transit damage Ensure certification are attached	<i>CZ</i>	<i>05/09/06</i>	<i>159</i>
4	QC6	Inspect dimensions per Dwg D2600 Check Pull test per Dwg D2600 for compliance page attached. Check hardness with Webster tester	<i>Z</i>	<i>05-12-21</i>	<i>159</i>
5	ST	Identify and Stock	<i>PL</i>	<i>05-12-21</i>	<i>159</i>
6	AC	Cost / part	<i>U</i>	<i>06-09-14</i>	
7	DC	Close W/O Inspect Level 21	<i>LD</i>	<i>06/09/14</i>	<i>159</i>

Rev	Date	Change	Revised By	Approved
A	98.12.02	New Issue	DM	
B	00.01.24	Second Pull test removed	EC	
C	01.03.29	Changed part# to -120	EC	
D	02.09.10	Added DSK 066	KJ. RF	<i>LD</i>

RELEASED
02/09/17 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 26/09/14

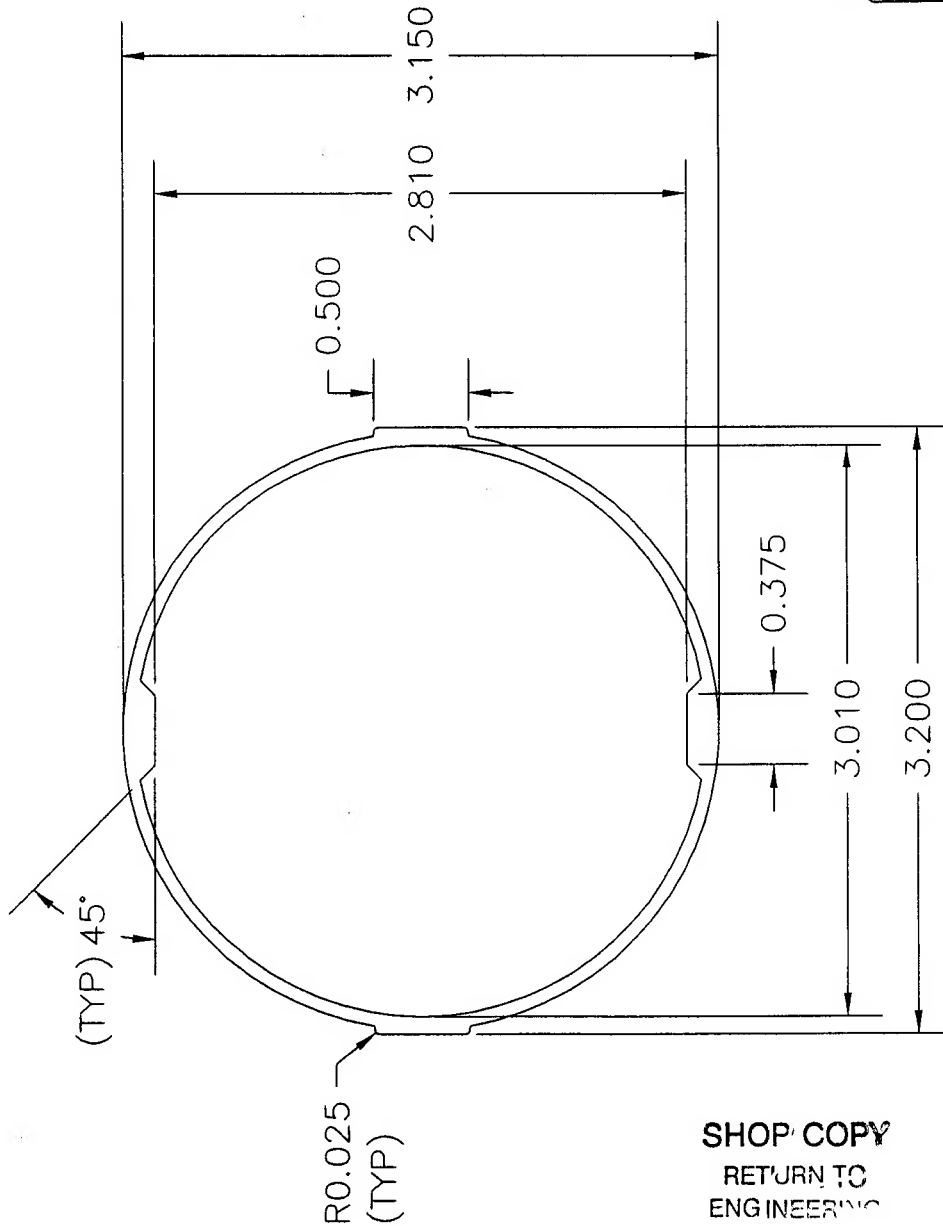
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>DA</i>	DRAWN BY <i>DA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DA</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)



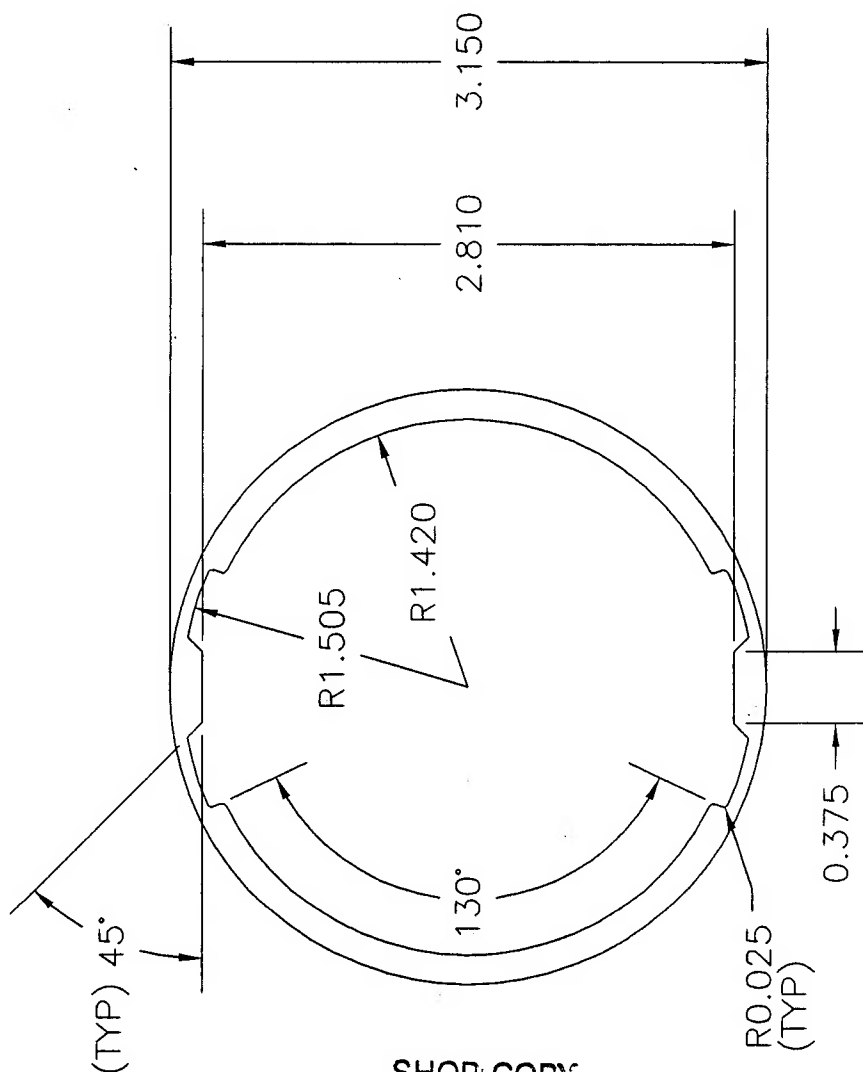
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WITHOUT

WORK ORDER
NO. 23201



DESIGN <i>DR</i>	DRAWN BY <i>DR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>CH</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



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WITHOUT NOTICE
WORK ORDER
NO. 23201

D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

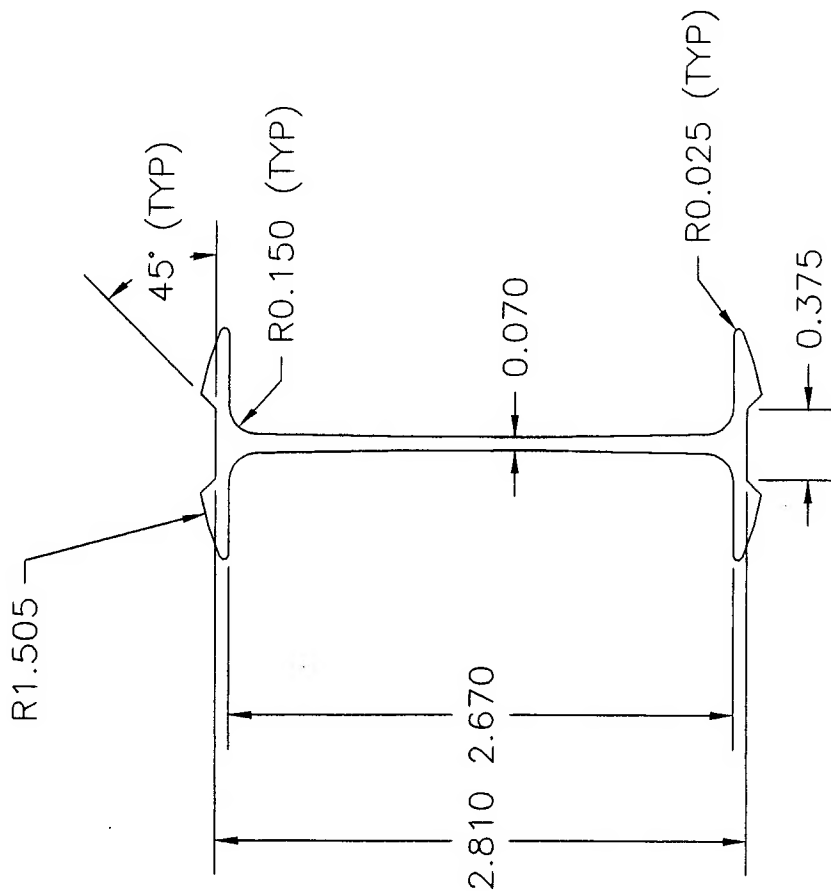
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)





DESIGN <i>ME</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED
98.8.25. DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



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WITHOUT NOTICE

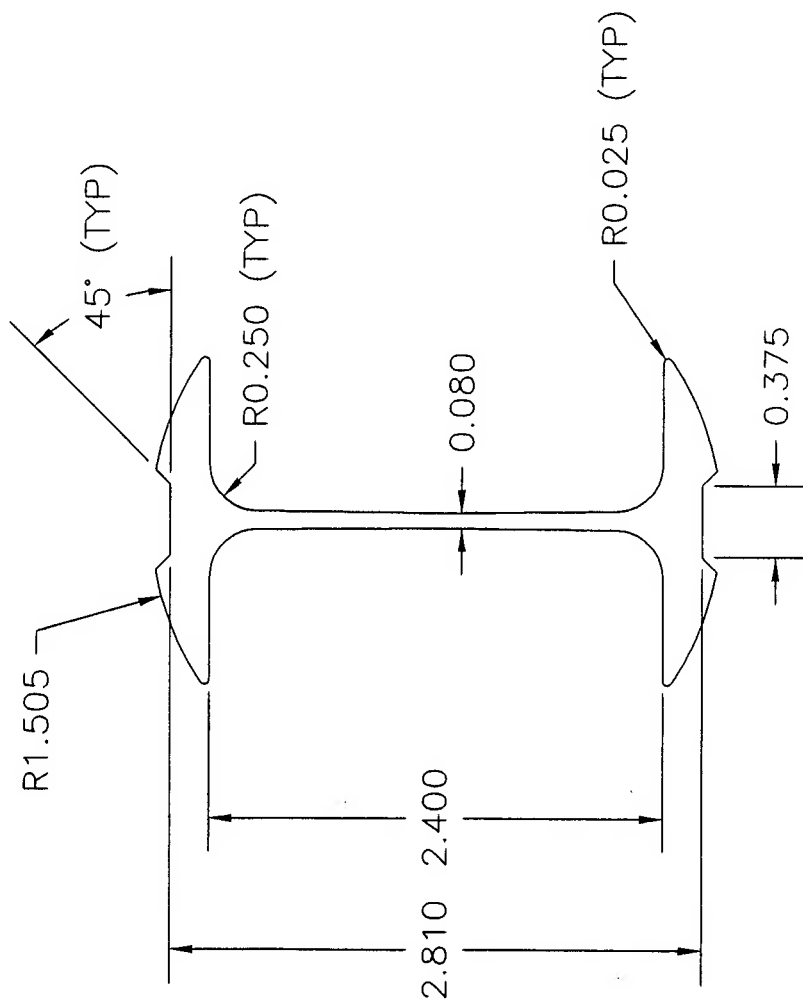
WORK ORDER

NO. 23201



DESIGN <i>DR</i>	DRAWN BY <i>DR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



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**SUBJECT TO AMENDMENT
WITHOUT NOTICE**

WORK ORDER

NO. 43201

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2005
09:55 am

Work Order No : 0023201
Project Name : D2600-3-120
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D2600-3-120
Description : Extrusion Round 3" 350
Manufactured : Yes
Amount Req'd : 120
Amount Done : 0
Start Date : 05-05-05
Est Finish Date : 06-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



ACCT# 00046024

BON L CANADA INC
1850 CLEMENTS ROAD
PICKERING ON

L1W 3R8

MANIFEST DATE/DATE D'EXPÉDITION

09-04-05

MANIFEST NUMBER/N° D'EXPEDITION

464654

SALES ORDER NUMBER/N° DE COMM.

52195

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.

CREDIT REP
REP DU CRÉDIT
SMITH, JOANN
770-252-0161

SALES REP
REP. DES VENTES

SHIP TO/EXPÉDIÉ À
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY
G6A 1K7

ON
CN

SOLD TO/VENDU À
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY
K6A 1K7

ON
CN

* * * * *

O/P

* * * * *

PHONE 613-632-3336

PHONE 613-632-3336

LOC/USINE

TRAILER NO./N° DE REMORQUE

SALESMAN/VENDEUR

PIC

66141

52305

FIELD SALES REP
REP. REGIONAL DES VENTES
Kuttler A

	CUST SERVICE REP
S	REP SERVICE CLIENTÈLE

CLIENT ID/N° DU CLIENT

ORDER DATE

~~CUST. P.O. NO. N° DE COMM. DU CLIENT~~

JOB/PROJET	
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BILL OF LADING NUMBER/N° DE CONNAISSEMENT	
---	--

46024

DATE DE LA COMMANDE
05/11/05

2008021

00276456

FIELD SALES REP
REP REGIONAL DES VEN
Kutter A
450-435-6551

CUST SERVICE REP
REP SERVICE CLIENTÈLE
burton D
905-427-2227

ITEM NO. ITEM	ORDER QUANTITY QTE. COMMANDEE	UNIT UNITE	PREVIOUS SHIPPED QTY QTE. DEJA EXPEDIEE	MFG. PART NUMBER N° DE PIECE DU FOURNISSEUR	ALLOY & TEMPER ALLIAGE & TREMPÉ	FINISH DESCRIPTION DESC. DE LA FINITION	THIS SHIPMENT/CETTE EXPEDITION			UNIT UNITE	QUANTITY DUE QUANTITE PREVUE
				CUSTOMER PART NUMBER NUMERO DE PIECE DU CLIENT	LENGTH LONGUEUR	FABRICATION DESCRIPTION TYPE DE FABRICATION	NO. PKGS. N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET		
					CUTTING TOLERANCE TOLERANCE DE COUPE	SHIPPING TOLERANCE TOLERANCE D'EXPEDITION					
01	140	KG M PC	0 0 0	DAA-897122-1 D2600-3-120	6061 T6 120" +3/16 " -0 "	MILL CERTIFICATE OF COMP (+010-010, 0154-0126)	3	1137	1119	KG M PC	
				DETAIL; LOT/TICKET		52195010 / 144912 52195010 / 144913 52195010 / 144914	1 1 1	379 379 379	373 373 373		53 PC 53 PC 53 PC
							3	1137	1119	KG	
									484	M	
									159	PC	
							TOTALS/TOTAUX				

FORM NO. B1065 REV. C

RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION

LE RETOUR DE MATERIEL NE SERA ACCEPTE POUR CREDIT SANS AUTORISATION

CUSTOMER

CLIENT

PAGE 1

**CUSTOMER
CLIENT**

PAGE

1

PROVINCE	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	2101	2102	2103	2104	2105	2106	2107	2108	2109	2110	2111	2112	2113	2114	2115	2116	2117	2118	2119	2120	2121	2122	2123	2124	2125	2126	2127	2128	2129	2130	2131	2132	2133	2134	2135	2136	2137	2138	2139	2140	2141	2142	2143	2144	2145	2146	2147	2148	2149	2150	2151	2152	2153	2154	2155	2156	2157	2158	2159	2160	2161	2162	2163	2164	2165	2166	2167	2168	2169	2170	2171	2172	2173	2174	2175	2176	2177	2178	2179	2180	2181	2182	2183	2184	2185	2186	2187	2188	2189	2190	2191	2192	2193	2194	2195	2196	2197	2198	2199	2200	2201	2202	2203	2204	2205	2206	2207	2208	2209	2210	2211	2212	2213	2214	2215	2216	2217	2218	2219	2220	2221	2222	2223	2224	2225	2226	2227	2228	2229	2230	2231	2232	2233	2234	2235	2236	2237	2238	2239	2240	2241	2242	2243	2244	2245	2246	2247	2248	2249	2250	2251	2252	2253	2254	2255	2256	2257	2258	2259	2260	2261	2262	2263	2264	2265	2266	2267	2268	2269	2270	2271	2272	2273	2274	2275	2276	2277	2278	2279	2280	2281	2282	2283	2284	2285	2286	2287	2288	2289	2290	2291	2292	2293	2294	2295	2296	2297	2298	2299	2300	2301	2302	2303	2304	2305	2306	2307	2308	2309	2310	2311	2312	2313	2314	2315	2316	2317	2318	2319	2320	2321	2322	2323	2324	2325	2326	2327	2328	2329	2330	2331	2332	2333	2334	2335	2336	2337	2338	2339	2340	2341	2342	2343	2344	2345	2346	2347	2348	2349	2350	2351	2352	2353	2354	2355	2356	2357	2358	2359	2360	2361	2362	2363	2364	2365	2366	2367	2368	2369	2370	2371	2372	2373	2374	2375	2376	2377	2378	2379	2380	2381	2382	2383	2384	2385	2386	2387	2388	2389	2390	2391	2392	2393	2394	2395	2396	239
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CERTIFICATE OF COMPLIANCE

BON L CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
09/04/05	126894	52195	1
Cust PO	B/L No	Lot	Date
2008021	00276456	52195010	9/04/05

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	1137 KGS		
Net Qty	1,119 KG	159 PC	485 M 3 PKG

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HR-E
1	326.0 / 47.3	304.1 / 44.1	12.5	.0	98
2	332.0 / 48.2	308.0 / 44.7	13.3	.0	98

Chemical Limits:

	SI	FE	CU	MN	MG	CR	ZN	TI	ZR	OTHER
MIN:	.400	.000	.150	.000	.800	.040	.000	.000	.000	EA: .050
MAX:	.800	.700	.400	.150	1.200	.350	.250	.150	.050	TOT: .150

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada

Conchita Ko

